

Work Order ID 50569

July 16, 2009 8:10:20 AM



Page 1

Item ID: D212-664-101TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 07/17/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 07-07-16 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D212-664-141	Rev C
--------------	-------

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA1131 2-Turn first side as per Folio FA1131 3-File down transition lines smooth.

a.m 09 - 07 - 17 ①

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

a.m 09 - 07 - 17 ①

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA1131 2-File down transition lines smooth. 3-Remove sand and plugs

a.m 09 - 07 - 17 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50569

July 16, 2009 8:10:20 AM



Page 2

Item ID: D212-664-101TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 07/17/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

A.m 09 - 07 - 17 ①

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 8 or 12/17

① ②

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

G.m 09 - 07 - 17 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50569

July 16, 2009 8:10:20 AM



Page 3

Item ID: D212-664-101TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 07/17/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



DP 9-7-20

QC

Memo

0.00

Quality Control

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and Stock in kanban rack Location:

X-TUBS <ELL ANM 9-7-20

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/20

MF 09-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 16, 2009 8:10:19 AM

Page 1

Work Order ID: 50569

Parent Item: D212-664-101TRNRevC

Parent Item Name: Crosstube Turning Detail

Comments:

Start Date: 07/17/2009

Required Date: 07/20/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6005-128RevA		Manufactured	No			120	Each	24.0000	1.0000			



Crosstube Material



Q.M 09-09-12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	24	
34686	1	
34775	2	
38337	21	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50569
Description: Crosstube Assembly (205/212/412 High Fwd)		Part Number:	D212-664-141
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200	/			
	R0.063	+/-0.010	R0.063	/			
	2.740	+0.005/-0.000	2.743	/			
	5.097	+/-0.030	5.097	/			
	2.304	+0.005/-0.000	2.309	/			
	2.340	+0.005/-0.000	2.345	/			
	2.398	+0.005/-0.000	2.403	/			
	2.448	+0.005/-0.000	2.453	/			
	2.498	+0.005/-0.000	2.503	/			
	2.549	+0.005/-0.000	2.554	/			
	2.599	+0.005/-0.000	2.604	/			
	2.671	+0.005/-0.000	2.676	/			
	2.701	+0.005/-0.000	2.706	/			
SIDE B	0.200	+/-0.010	0.200	/			
	R0.063	+/-0.010	R0.063	/			
	2.740	+0.005/-0.000	2.743	/			
	5.097	+/-0.030	5.097	/			
	2.304	+0.005/-0.000	2.309	/			
	2.340	+0.005/-0.000	2.345	/			
	2.398	+0.005/-0.000	2.403	/			
	2.448	+0.005/-0.000	2.453	/			
	2.498	+0.005/-0.000	2.503	/			
	2.549	+0.005/-0.000	2.554	/			
	2.599	+0.005/-0.000	2.604	/			
	2.671	+0.005/-0.000	2.676	/			
	2.701	+0.005/-0.000	2.706	/			
	126.51	+/-0.020	126.510	/			

Measured by:	A.M	Audited by:	S	Prototype Approval:	N/A
Date:	09.07.17	Date:	09/7/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	

DART

RELEASED

07.04.24

DEO ATTACHED

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED GP	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

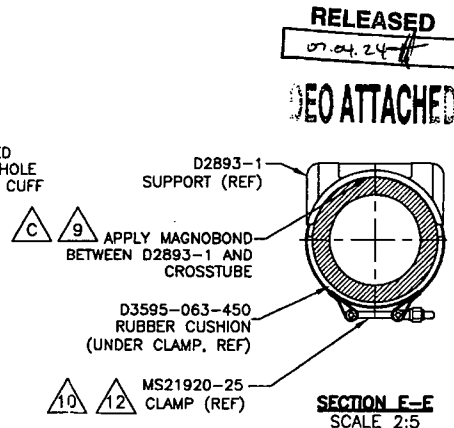
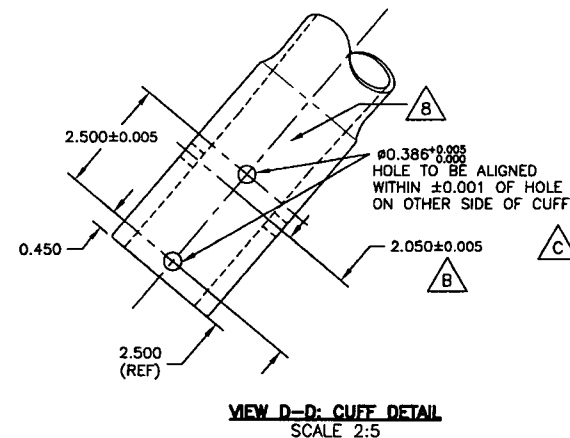
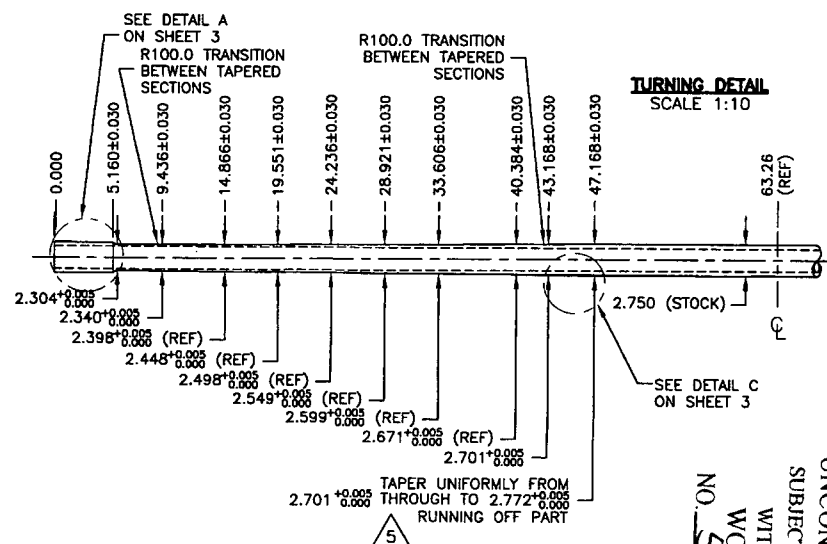
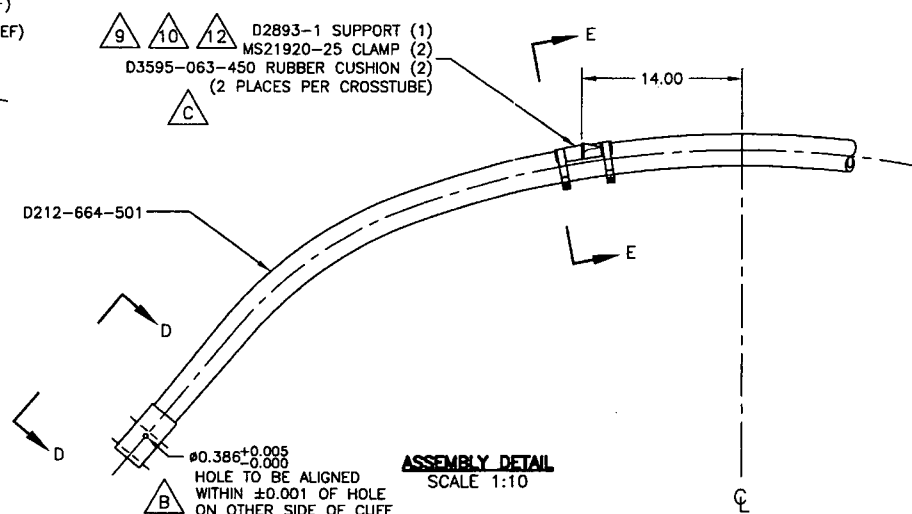
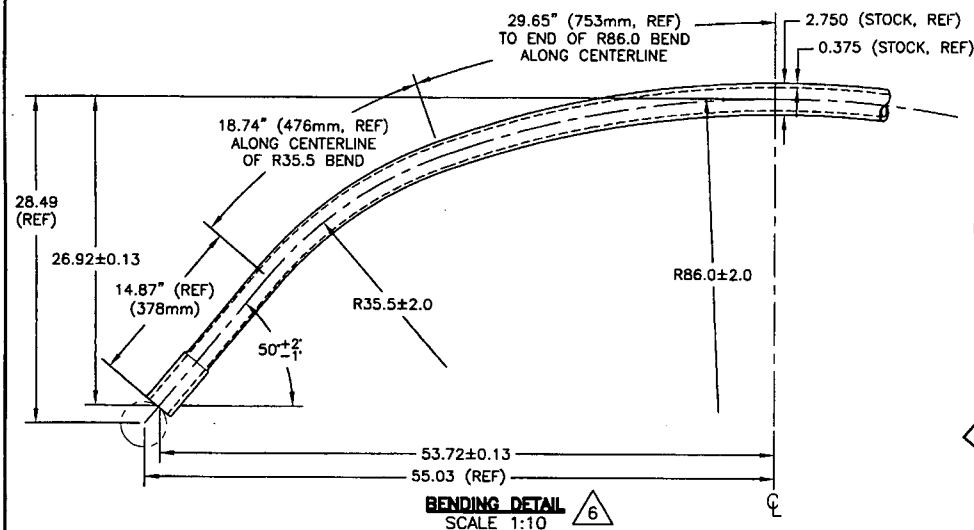
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.51 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50569

MF 09-07-16

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

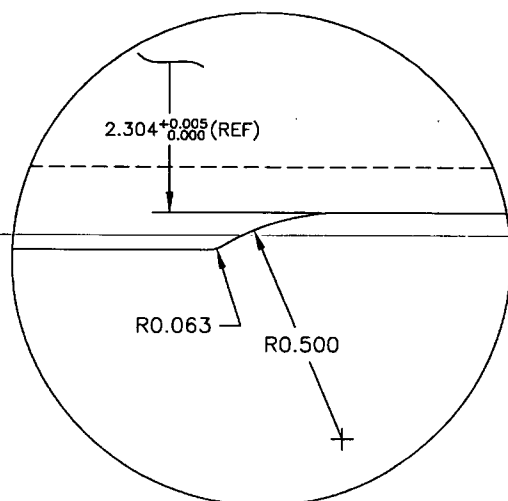
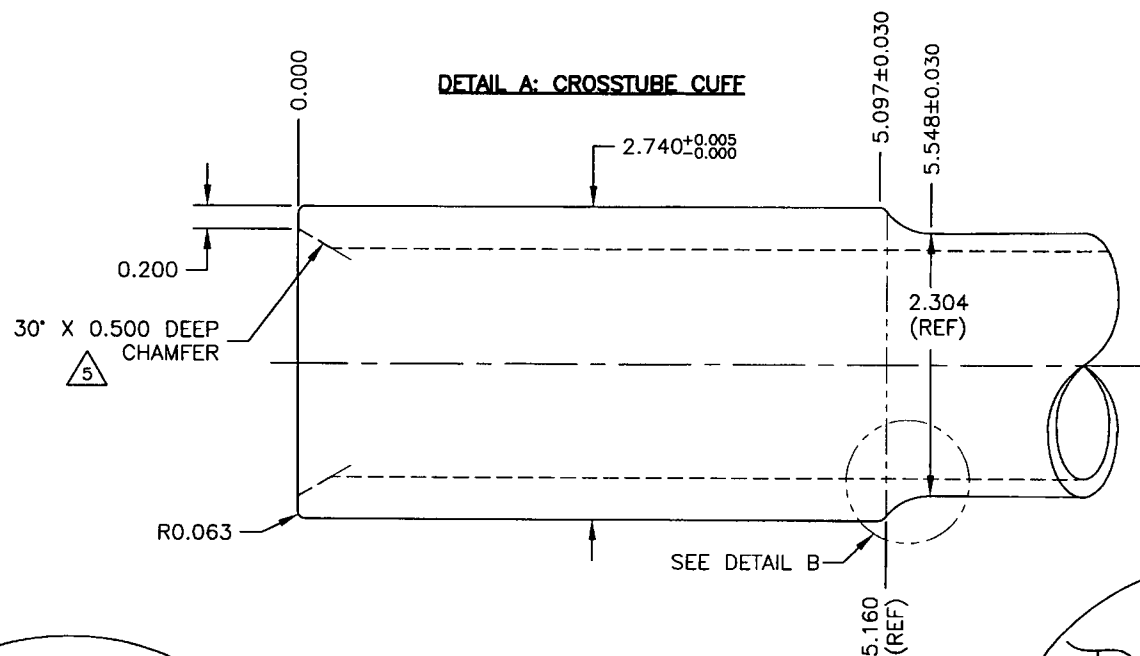


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50569
mf
09-07-16

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	REV. C
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	99	APPROVED	4		
		DATE	07.03.08	DRAWING NO.		D212-664-141	SHEET 2 OF 3
				TITLE		XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:10

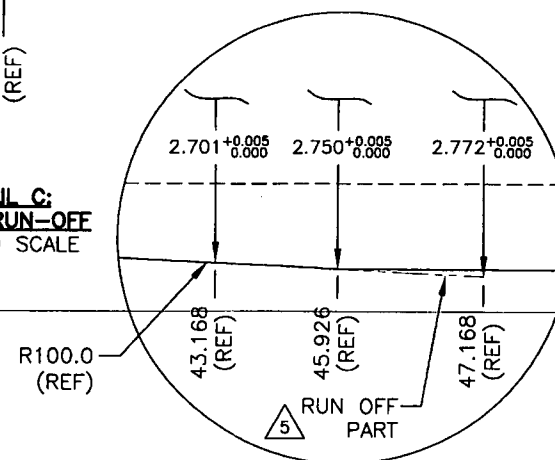
RELEASED
 07.04.24 (P)
 PER CLN 897

DEO ATTACHED



**DETAIL B: CUFF
 TRANSITION**
 SCALE 4:1

**DETAIL C:
 TAPER RUN-OFF**
 NOT TO SCALE



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 505169
 MFC
 09-07-16

COPYRIGHT © 2009 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
 AND IS SUPPLIED ON THE EXPRESS CONDITION
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE
 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.

DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. WARRICKSBURY, OHTARIO, CANADA
CHECKED J	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08	TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:1	

DRAWING NO. D212-664-141	TITLE CROSSTUBE	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AD</i>	CHECKED <i>RS</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MD</i>	DE APPR. <i>TH</i>		
DATE 09.05.01	DATE 09.06.15	DATE 09.06.15	DATE 09/06/16	DATE 09/06/16		

CHANGE:

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)

THE D212-664-141B CROSSTUBE HAS THE SAME PARTS LIST AS THE D212-664-141 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D212-664-141 CROSSTUBE.

RELEASED
07/06/22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *50529*
mf
09-07-16

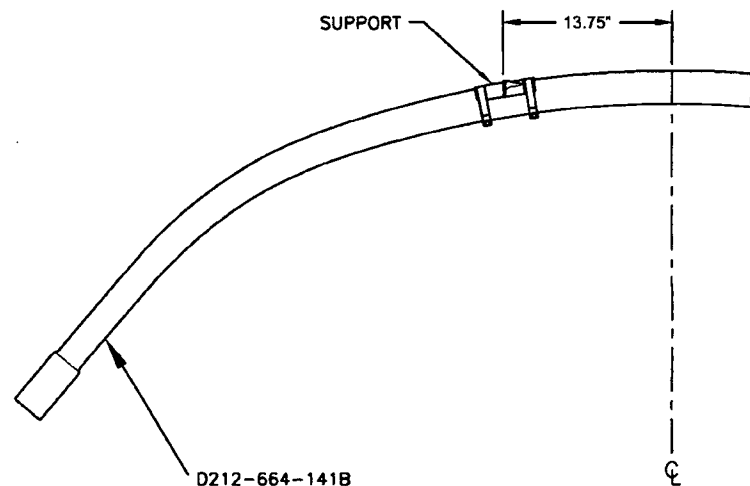


FIGURE 1 - SUPPORT INSTALLATION